

**Work Order ID 69608**

Thursday, May 12, 2011 3:33:22 PM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11/05/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

E 5/11/06/13 (4)

E 5/11/06/13 (4)

(44)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69608**

Page 2

Thursday, May 12, 2011 3:33:22 PM

Item ID: D3912-041

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Setup Start



Revision ID:

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Item Name: Eyebolt Receiver Assembly

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>507</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/13 (4)

11/6/14

11-06-13  
(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 12, 2011 3:33:29 PM

Page 1

Work Order ID: 69608

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B  
10.06.10 memo in seq110 \*\*\*IF PLUNGER GOES IN TO DEEP, INSTALL A  
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND  
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO  
FIT\*\*\* DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM  
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R  Washer		Purchased	No				Each	246.0000		4		5/11/06/13	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST297			246					
					110139			46					
					116893			200					
D3912-1  Eyebolt		Manufactured	No			100	Each	8.0000	1	4		5/11/06/13	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST091			8					
					68380			8					
<del>D3912-3</del>  Eyebolt Block		Manufactured	No			100	Each	11.0000	2	8		5/11/06/13	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST091			11					
					68378			7					
					68973			4					

369606 (2)

B69539 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 12, 2011 3:33:30 PM

Work Order ID: 69608

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100

Each

16.0000

2



Eyebolt Plate

Location

Loc Qty

Loc Code

ST091

16

66160

1

68381

10

69001

5

D3801-1 Manufactured No

Each

8.0000



Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST084

8

68379

8

MS20615-4M20 Purchased No

100

Each

180.0000

8



RIVET

Location

Loc Qty

Loc Code

GA

180

117071

180

MS21209-F615 Purchased No

Each

51.0000



Heli-Coil

Location

Loc Qty

Loc Code

ST305

51

108170

30

108244

21

8  
EP 11/06/13

B69541 (42)

2  
2

4  
EP 11/06/13

B 69498

32  
EP 11/06/13

32

4  
EP 11/06/13

1  
3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

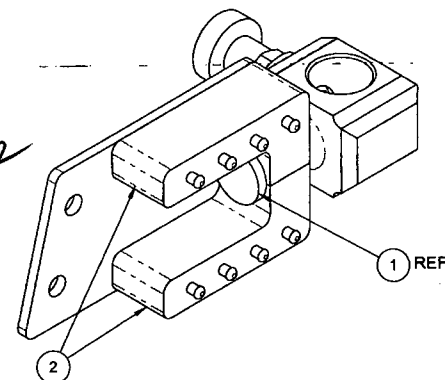
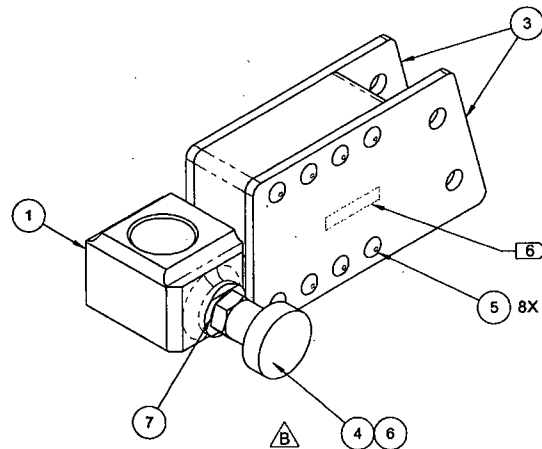
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



**SUPPLEMENTAL ISO VIEW**  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

**D3912-041 EYEBOLT RECEIVER ASSY**

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT -041: 1.58 lbs

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 69608

*PL 11-05-12*

**RELEASED**  
 2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>A/S</i>		
DRAWN	<i>JH</i>		
CHECKED	<i>JH</i>		
MFG. APPR.	<i>JH</i>		
APPROVED	<i>JH</i>		
DE APPR.	<i>JH</i>		
DATE	10.06.28		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA  
 DRAWING NO. **D3912**  
 TITLE **EYEBOLT RECEIVER ASSY**  
 SCALE **NTS**  
 REV. B  
 SHEET 1 OF 3  
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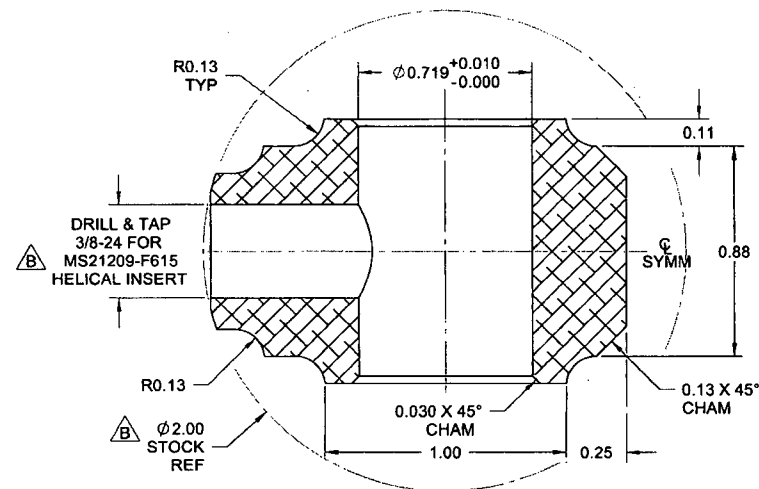
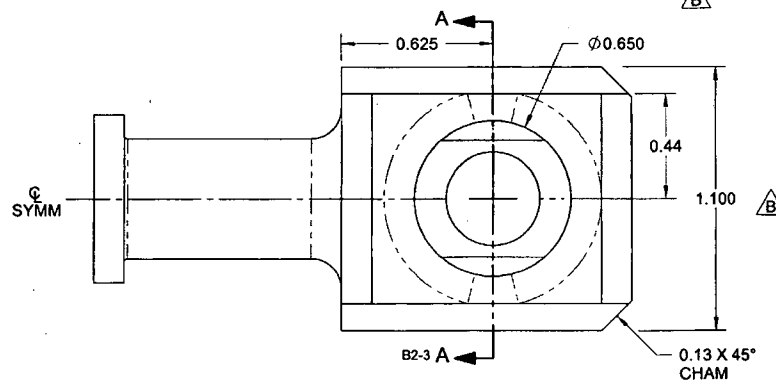
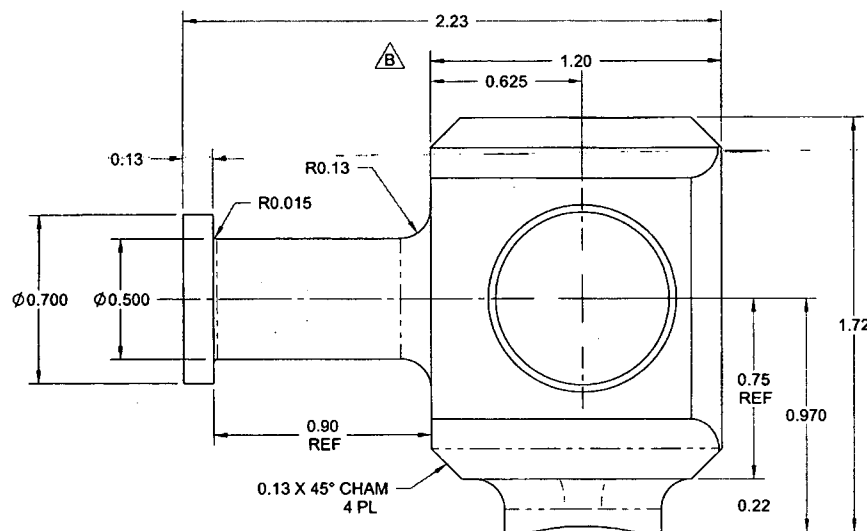
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



SECTION A-A B6-3

**RELEASED**  
2010-07-16

# D3912-1 EYEBOLT

## NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

B

*u1069608*

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3912	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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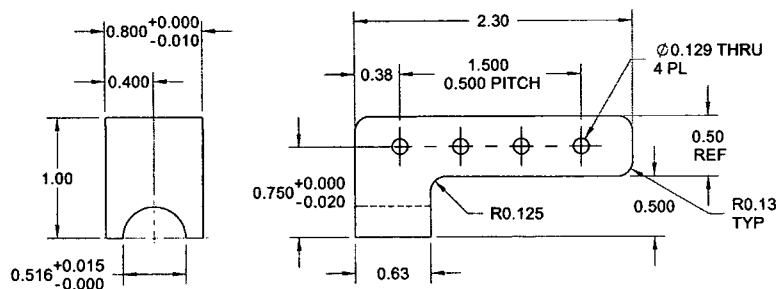
W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

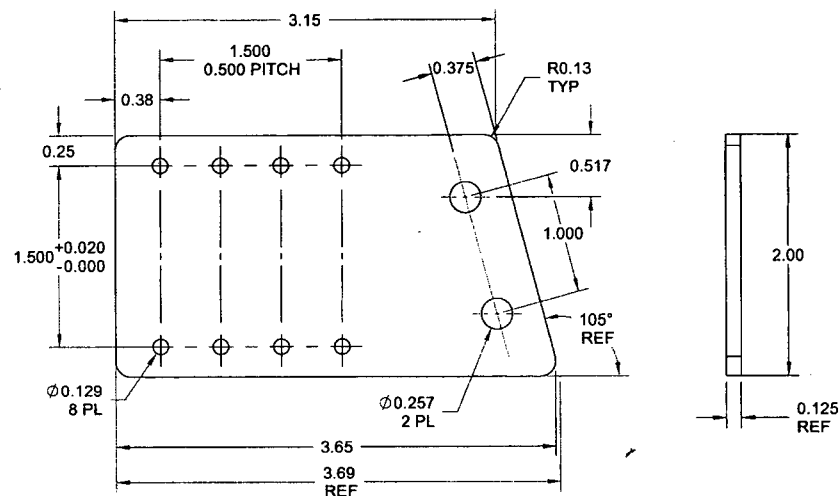
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



**D3912-3 EYEBOLT BLOCK**



**D3912-5 EYEBOLT PLATE**

**NOTES:**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

*u/o 69608*

**RELEASED**  
2010-07-16  
*and*

DESIGN	115	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3912	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>EYEBOLT RECEIVER ASSY</b>	
DATE	10.06.28	NTS	
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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